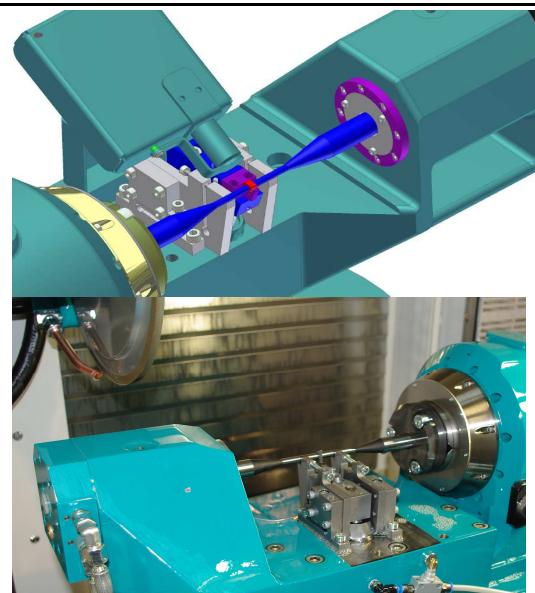


Triangular Insert K-Land Ø9.52

A08-200

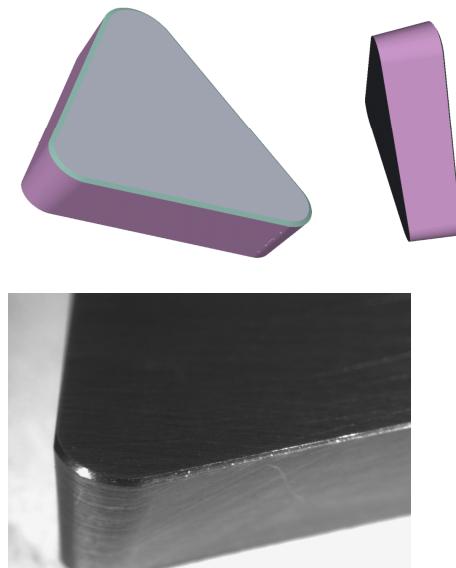
Non cylindrical OD Grinding with then main periphery of a biconical 1V1 Wheel. Pregrinding in 4, finishing in 2 complete rotations. K Land is ground with the secondary periphery of the biconical wheel. Materialremoval is approximately 0.5 mm radially.



1. Cycletime for

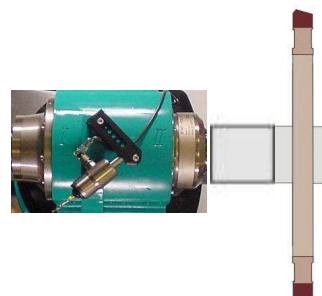
Workpiece: IC Ø9.52, t=4 mm Material PKD					
Operations	Dress	OD Clr. Preg	OD Clr. fin.	K-Land	Load
Feed [mm/Min]	100	350	350	350	9000
Power [kW]	4	3	2	2	1
Cutting feed [m/s]	22	32	32	32	
Used wheels	1	1	1	1	
Grinding time [s]	13	44	26	9	8
Total cycle time	1 Min 39				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

1	2VSW Ø300 D46
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3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 160i

Software: Quinto 5

Accessories: AVC, STL6050

Responsible engineer: OP. 12.10.09

www.schneeberger.ch

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